

# Work Order ID 120998

June-16-14 1:15:39 PM

**\*120998\***

Page 1

Item ID: D206-817-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Screw-In Windshield Modification

Start Date: 7/16/14

Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/25/14

Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-06-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9659	A
DSI9687	A
IIN-D206-817	D

100

Document Control

0.00

**\*100\***

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-817-011 CHG006

DEC 08 2014

2

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

DAS

26

9-89

2x

OCT 17 2014

DAS  
46  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 120998

June-16-14 1:15:39 PM

**\*120998\***

Page 2

Item ID: D206-817-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Screw-In Windshield Modification

Start Date: 7/16/14 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC4- 100% Inspect kits for completeness 0.00

**\*120\***

QC

Memo

0.00

Quality Control

2  
DEC 8 2014

130 Packaging 0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-817-011 Location: F6028

PPP Rev: \_\_\_\_\_

2  
DEC 8 2014

140 QC21- Final Inspection - Work Order Release 0.00

**\*140\***

QC

Memo

0.00

Quality Control

14/12/9

14-12-09

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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# Picklist Print

June-16-14 1:15:37 PM

Page 1

Work Order ID: 120998

\*120998\*

Parent Item: D206-817-011

\*D206-817-011\*

Parent Item Name: Screw-In Windshield Modification

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B  
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12  
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN  
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per  
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687  
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-1		Manufactured	No			110	Each	3.0000	1	2			
*D4541-1*										**			
Bracket												DAS 28 9-89	
												OCT 2 2 20	
												DAS 46 9-89	
												118995	
D4541-2		Manufactured	No			110	Each	13.0000	1	2			
*D4541-2*										**			
Bracket												DAS 28 9-89	
												1x B125732	
D4542-1		Manufactured	No			110	Each	9.0000	1	2			
*D4542-1*										**			
Retainer, Inner, LH												DAS 28 9-89	
												122802	

DAS  
28  
9-89

OCT 22 2014

DAS  
46  
9-89

DAS  
46  
9-89

DAS  
28  
9-89

DAS  
46  
9-89

DAS  
28  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

June-16-14 1:15:37 PM

Page 2

Work Order ID: 120998

\*120998\*

Parent Item: D206-817-011

\*D206-817-011\*

Parent Item Name: Screw-In Windshield Modification

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

D4542-2 Manufactured No

110 Each

9.0000

1 2

DAS  
28  
9-89

OCT 22 2014

\*D4542-2\*

Retainer, Inner, RH

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

prelim

1

115283

1

ST531

8

116101

8

121155

DAS  
46  
9-89

D4541-3 Manufactured No

110 Each

10.0000

1 2

DAS  
28  
9-89

DAS  
46  
9-89

\*D4541-3\*

Bracket

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

prelim

6

115218

6

st530

4

109382

4

123618x1  
1x

D4541-4 Manufactured No

110 Each

11.0000

1 2

DAS  
28  
9-89

DAS  
46  
9-89

\*D4541-4\*

Bracket, RH

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

prelim

10

115295

10

st530

1

109484

1

123665

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

June-16-14 1:15:37 PM

Page 3

Work Order ID: 120998

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

\*120998\*

\*D206-817-011\*

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

D4541-5 Manufactured No 110 Each 9.0000 1 2

\*D4541-5\*

Bracket, LH

DAS  
06  
9-89

Location

Loc Qty

Loc Code

prelim 115219 1

ST525 115920 8

\*\*

DAS  
28  
9-89

OCT 22 2014

DAS  
46  
9-89

D4541-6 Manufactured No 110 Each 11.0000 1 2

\*D4541-6\*

Bracket, RH

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST525 115293 3  
116674 8

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

D4541-7 Manufactured No 110 Each 10.0000 1 2

\*D4541-7\*

Bracket

DAS  
06  
9-89

Location

Loc Qty

Loc Code

prelim 115220 2  
ST525 116104 8

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

D4541-8 Manufactured No 110 Each 10.0000 1 2

\*D4541-8\*

Bracket

DAS  
06  
9-89

Location

Loc Qty

Loc Code

st527A 115956 10

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

June-16-14 1:15:37 PM

Shop Packet Print

Page 3

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# Picklist Print

June-16-14 1:15:37 PM

Page 4

Work Order ID: 120998

**\*120998\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

D4542-3 Manufactured No

110 Each 5.0000 ~2 4

**\*D4542-3\***

Retainer, Inner

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST532

5

110159

4

111485

1

\*\*

DAS  
28  
9-89

DAS  
46  
9-89  
OCT 22 2014

121013

D4542-5 Manufactured No

110 Each 2.0000 2 4

**\*D4542-5\***

Retainer, Inner

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST532

2

115893

2

\*\*

DAS  
28  
9-89

126360

125021 x 25000  
incorrect  
Rev

D4542-7 Manufactured No

110 Each 10.0000 2 4

**\*D4542-7\***

Retainer, Inner

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST532

10

116675

10

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

119036

D4543-1 Manufactured No

110 Each 2.0000 1 2

**\*D4543-1\***

Retainer, LH Outer (Lower)

DAS  
28  
9-89

Location

Loc Qty

Loc Code

st526

2

111498

2

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

121031

June-16-14 1:15:37 PM

Shop Packet Print

Page 4

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

June-16-14 1:15:38 PM

Page 6

Work Order ID: 120998

**\*120998\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

D4543-6 Manufactured No

110 Each 10.0000 1 2

**\*D4543-6\***

Retainer, Outer, RH

\*\*

DAS  
46  
9-89

DAS  
28

OCT 2 1 2014

DAS  
06  
9-89

Location

Loc Qty

Loc Code

st529

10

108205

2

115993

8

123666

D4544-1 Manufactured No

110 Each 2.0000 1 2

**\*D4544-1\***

Retainer, Center

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

st530

2

108026

2

121043

D4594-1 Manufactured No

110 Each 4.0000 1 2

**\*D4594-1\***

Plate

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

prelim

4

115222

4

122300

D4595-150-13 Manufactured No

110 Each 17.0000 2 4

**\*D4595-150-13\***

Sealant Tape (13' Long)

\*\*

DAS  
28  
9-89

DAS  
46  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST525

17

116922

3

119831

14

120054

June-16-14 1:15:38 PM

Shop Packet Print

Page 6

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# Picklist Print

June-16-14 1:15:38 PM

Page 7

Work Order ID: 120998

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

\*120998\*

\*D206-817-011\*

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

AN525-10R7

Purchased

No

110

Each

1,161.000

95

190

\*AN525-10R7\*

SCREW

\*\*

OCT 21 2014

DAS  
28  
9-89

DAS  
28  
9-89

## Location

## Loc Qty

## Loc Code

ST344

2

m127447

2

ST505

1159

m127815

409

m128429

750

129706X40

150X

MS20426AD3-4

Purchased

No

110

Each

6,918.000

190

380

\*MS20426AD3-4\*

RIVET

\*\*

DAS  
28  
9-89

DAS  
28  
9-89

## Location

## Loc Qty

## Loc Code

MF4

265

125578

265

ST334

2917

m127432

2917

ST509

3736

125578

3736

380X

MS21059L08

Purchased

No

110

Each

713.0000

43

86

\*MS21059L08\*

Nut

\*\*

OCT 20 2014

DAS  
28  
9-89

DAS  
28  
9-89

## Location

## Loc Qty

## Loc Code

ST508

713

123185

1

125654

712

129934

June-16-14 1:15:38 PM

Shop Packet Print

Page 7

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

June-16-14 1:15:38 PM

Page 8

Work Order ID: 120998

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

\*120998\*

\*D206-817-011\*

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

MS21059L3K

Purchased

No

110

Each

1,149.000

93

186

\*MS21059L3K\*

Nutplate

## Location

## Loc Qty

## Loc Code

GA

179

m127635

179

ST305

500

m129472

500

ST316

470

m127703

16

m129198

454

129913X164

22X

DAS  
26  
9-89  
46

MS21061L08

Purchased

No

110

Each

130.0000

10

20

\*MS21061L08\*

Nutplate

## Location

## Loc Qty

## Loc Code

ST317

130

m128635

130

20X

DAS  
26  
9-89  
46

MS21075L08

Purchased

No

110

Each

350.0000

1

2

\*MS21075L08\*

ANCHOR NUT

## Location

## Loc Qty

## Loc Code

ST318

350

M128635

200

M128813

150

2X

OCT 17 2014  
DAS  
26  
9-89  
46

June-16-14 1:15:38 PM

Shop Packet Print

Page 8

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

June-16-14 1:15:38 PM

Page 9

Work Order ID: 120998

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

**\*120998\***

**\*D206-817-011\***

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-10

Purchased

No

110

Each

1,854.000

42

84

**\*MS27039-08-10\***

Screw

\*\*

DAS  
26  
9-89



Location

Loc Qty

Loc Code

Mezz

6

5865

6

ST307

1848

123265

47

m127430

25

m128799

1776

84

NAS1149DN832J

Purchased

No

110

Each

3,230.000

42

84

**\*NAS1149DN832J\***

Washer

\*\*

DAS  
26  
9-89

OCT 17 2014



Location

Loc Qty

Loc Code

MF4

616

M127255

616

ST277

1000

M129499

1000

ST293

1458

M128948

474

M128429

984

st510

145

124555

145

ST510a

11

M126319

11

72x

12x

June-16-14 1:15:38 PM

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Page 9

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

June-16-14 1:15:38 PM

Page 10

Work Order ID: 120998

**\*120998\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

Start Date: 7/16/14

Required Date: 7/25/14

Start Qty: 2.00

Required Qty: 2.00

MS21061L3K

Purchased

No

110

Each

42.0000

2

4

DAS

28

9-89

OCT 17 2014

**\*MS21061L3K\***

NUT PLATE

**\*\***

Location

Loc Qty

Loc Code

GA

4

125268

4

ST317

38

123603

38

DAS  
28  
9-89

DAS  
46  
9-89

4

June-16-14 1:15:38 PM

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Page 10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2  
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3  
REF. FAA STC: SR03091NY  
REF. EASA STC: 10039042

## 1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

## 2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

## 3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

## 4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 120098 M/S  
14-06-17

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 13.06.20  
CERT. NO.: SH12-3  
ISSUE NO.: 1

A	NEW ISSUE	OS	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	OS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	OS		
CHECKED	14	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	SEALANT TAPE	NTS
DATE	13.06.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D  
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2  
REF. TCCA STC SH12-3  
REF. FAA STC SR03091NY  
REF. EASA STC 10039042

## 1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

## 2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)




(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 14.03.18  
CERT. NO.: SH12-3  
ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
DATE	14.03.18	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



### 3.0 INSTALLATION

IF INSTALLING A D206-817-011 KIT AT CHG 005 OR LATER, STEP 3.3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV D IS MODIFIED IS FOLLOWS:

- 3.3 Install Dart inner retainers. It is acceptable to hand form retainers as required to allow fit. Retainers should be located so that they are approximately flush with the aircraft skin. Locate retainers and transfer drill Ø0.128" from aircraft frame. Locate as follows, using Figure 3-2 as reference:
- Locate D4541-1/-2 Brackets along the bottom window frame flush against the door pillars. The Bracket should be oriented with the hole pattern for the MS21061L3K nutplate (the non-symmetric nutplate, ref) near the door post. See Figure 3-3 for reference.
  - Locate D4541-3/-4 Brackets on the door pillars, above the -1/2 Brackets. See Figure 3-3.
  - Locate D4541-5/-6 Brackets above the -3/-4 retainers. See Figure 3-4.
  - Locate D4541-7/-8 Brackets along the top edge, with one side aligned with the center column. See Figure 3-4.
  - Relocate the 206-031-112-039 (or equiv.) clip removed at step 3.2(g) per Figure 3-3.

Install brackets wet with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 sealant between retainers and a/c frame. Fasten D4541-1/-2 Lower Inner Brackets with CR3214-4 (or NAS9301B or M7885/2) rivets and NAS1149DN432J (or 140-001-1 or AN960JD4 or equiv.) washers. Fasten D4541-X Brackets with MS20600AD4 rivets. Reinstall clip (206-031-112-039 or equiv.) with CR3213-4 rivets. See Figure 3-3 for reference.

\*Note: Due to variations in airframes the D4541-X Brackets have been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

- 3.4 Locate D4542-X Retainers onto the D4541-X Brackets as follows, see Figures 3-3 & 3-4 for reference:

- Locate D4542-1 Retainers onto the D4541-1/-2 Brackets
- Locate D4542-3 Retainers onto the D4541-3/-4 Brackets
- Locate D4542-5 Retainers onto the D4541-5/-6 Brackets
- Locate D4542-7 Retainers onto the D4541-7/-8 Brackets

Hand form D4541-X Brackets and/or D45421-X as required to fit profile of windshield. Locate and transfer drill rivet holes to D4542-X Retainers and open to Ø0.098. Locate and transfer drill screw holes and open to Ø0.250". Dimple the Ø0.098 holes Ø0.180 x 100° and install MS21059L3K nutplates with MS20426AD3-4 rivets.

\*Note: Due to variations in airframes the D4542-5 Retainer has been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

FIGURES 3-2 & 3-3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D ARE MODIFIED AS SHOWN ON SHEETS 3 AND 4 OF THIS SERVICE INSTRUCTION.

### 4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

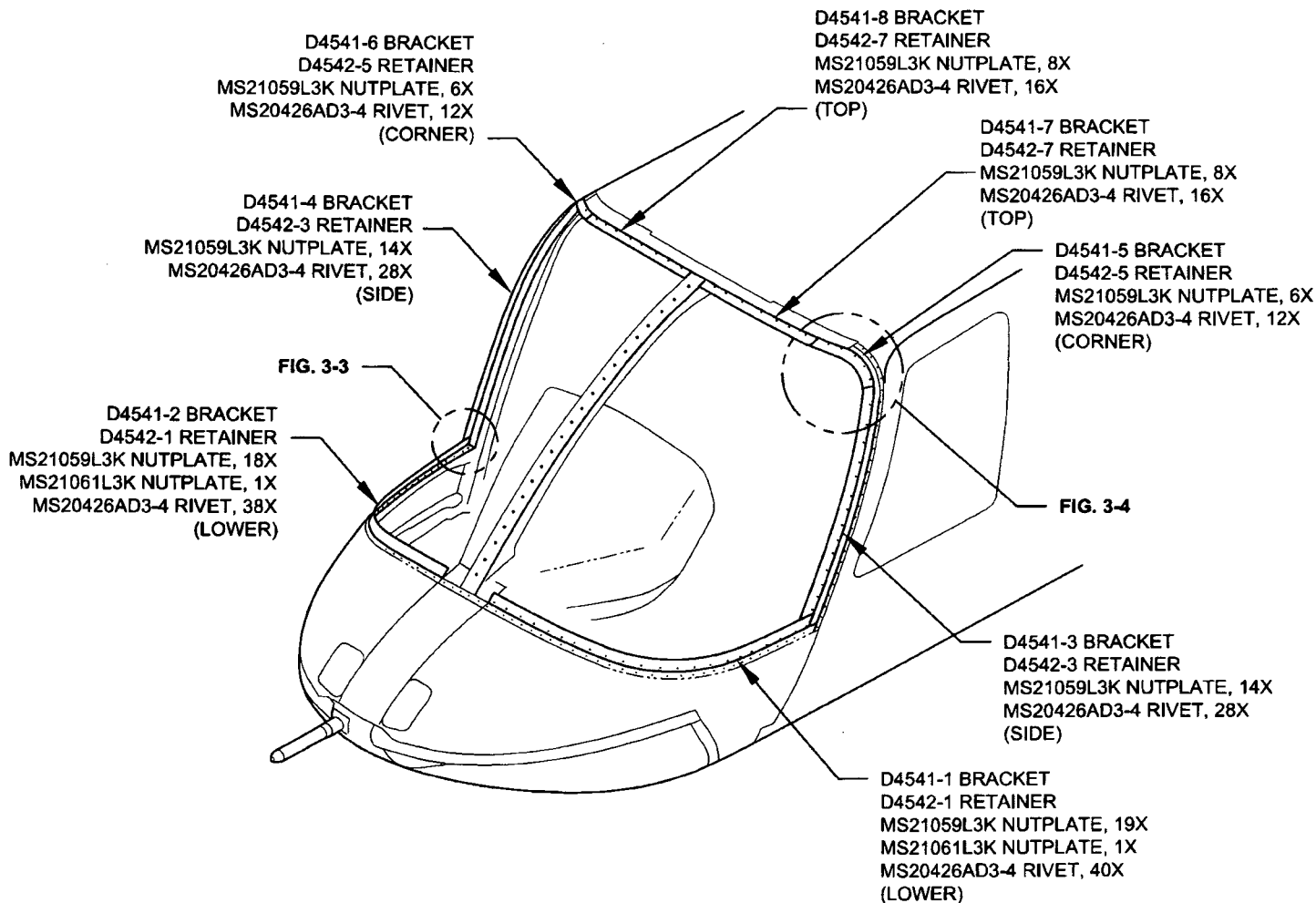
DATE: 14.03.18

CERT. NO.: SH12-3

ISSUE NO.: 1

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER KIT	NTS
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**FIGURE 3-2**  
(REF IIN-D206-817 REV D)

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DAO # 01-O-01

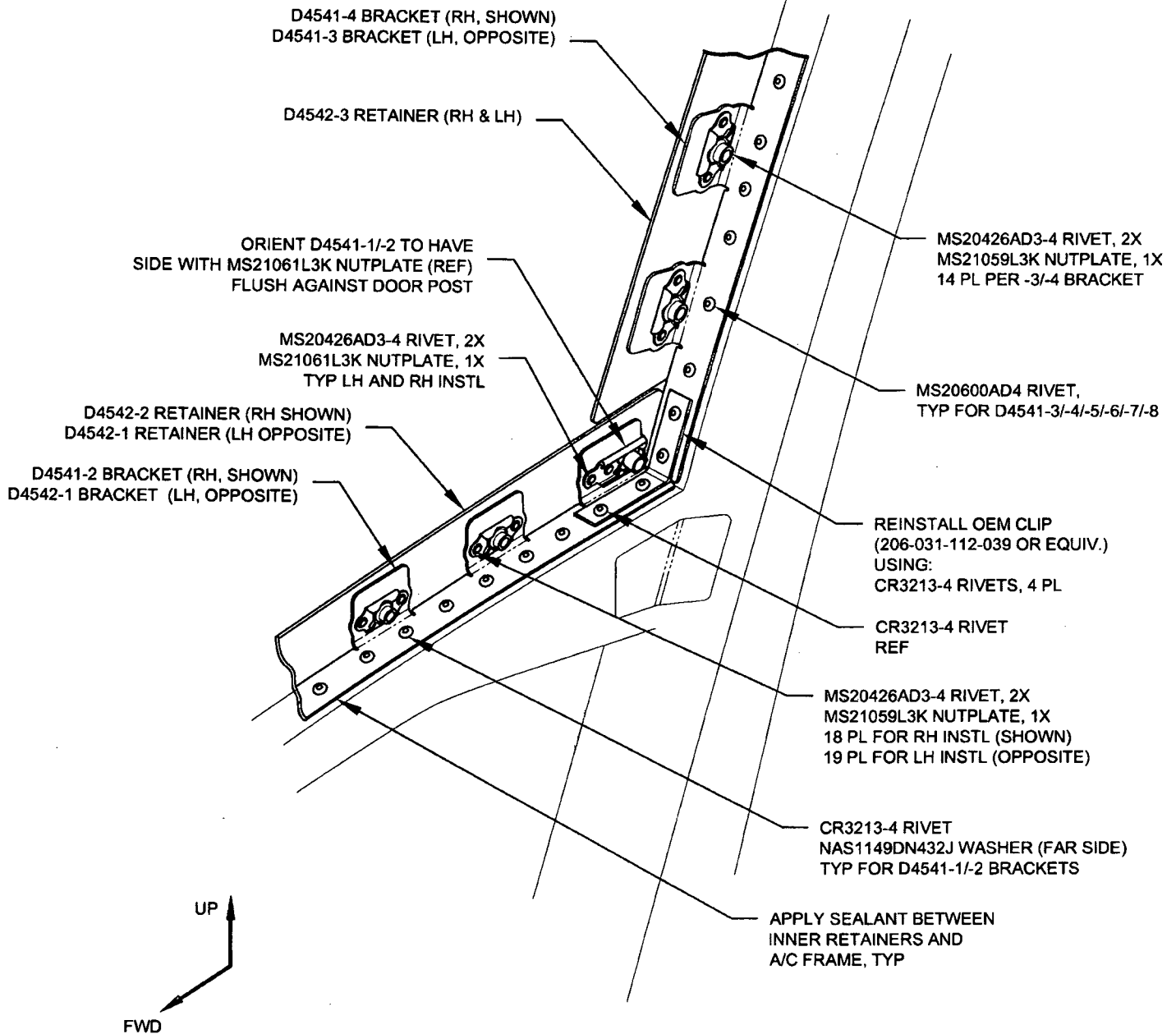
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BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 14.03.18  
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MFG. APPR.	N/A	DSI 9687	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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**FIGURE 3-3**  
(REF IIN-D206-817 REV D)

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DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 14.03.18

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MFG. APPR.	N/A	DSI 9687	SHEET 4 OF 4
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#### 4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

#### 5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-3	BRACKET, LH
1	D4541-4	BRACKET, RH
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
1	D4541-7	BRACKET, LH
1	D4541-8	BRACKET, RH
2	D4542-3	RETAINER, INNER
2	D4542-5	RETAINER, INNER
2	D4542-7	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4543-5	RETAINER, LH OUTER (SIDE)
1	D4543-6	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
10	MS21061L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D  
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2

REF. TCCA STC SH12-3  
REF. FAA STC SR03091NY  
REF. EASA STC 10039042

## 1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

## 2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)




QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 14.03.18  
CERT. NO.: SH12-3  
ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2  
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3  
REF. FAA STC: SR03091NY  
REF. EASA STC: 10039042

## 1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

## 2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

## 3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.







## 4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 13.06.20  
CERT. NO.: SH12-3  
ISSUE NO.: 1

A	NEW ISSUE		13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
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# Work Order ID 120998

\*120998\*

Page 1

June-16-14 1:15:39 PM

Item ID: D206-817-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Screw-In Windshield Modification

Start Date: 7/16/14 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-06-17

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9659	A								
DSI9687	A								
IIN-D206-817	D								
100	Document Control	0.00							
*100*	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-817-011 - CHG005								
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging									

CHG 006 14/9/23

MLJ 14-10-17

2

